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D5275-041
Job Sheet 192139



Part No: D5275-041

Job Qty: 20 ea

Part Name: Door Latch Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.09.24 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	3/22/19	3/22/19	0.00	0.00	Start Up Stores/Pkg-2		DAS 36 9-89
120	Packaging	20 pcs	3/22/19	3/22/19	0.00	0.00	Packaging1-5		36 DAS 9-89
130	Small Fab	20 pcs	3/22/19	3/22/19	0.00	1.67	Small Fab-8		36 DAS 9-89
140	QC	20 pcs	3/22/19	3/22/19	0.00	0.00	QC5		40 DAS 9-89
150	Packaging	20 pcs	3/22/19	3/22/19	0.00	0.00	Packaging3-2		MAR 2 1 2019 40 9-89
160	QC21-SA	20 Ea	3/22/19	3/22/19	0.00	0.00	QC21		MAR 2 2 2019 21

Part Op 120 - Pick Kit

Descriptions: 130 - 1- Drill out existing threads to 0.191" 2- Counterface as per Dwg 3-Drill out existing rivet to 0.128" as per dwg. 4- Touch up with chemical conversion as per dwg. note 2 5- Assemble Lock Nut to Hinge. Leave Latch Unlocked. ***Ensure key is bag with latch and gasket***

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: _____ ***Ensure key is bag with latch***

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3015-7	Lock Nut	20 pcs (1 ea)	90-Start up Operation	5128927
D5275-1	Door Latch	20 pcs (1 ea)	90-Start up Operation	5016769
CR3213-4-05	Rivet	20 Ea (1 ea)	90-Start up Operation	5152647 (11) 5016769 (5x) FM138326-3

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3213-4-05	20	99	0
	D3015-7	20	31	0
	D5275-1	20	16	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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UK

CHARTER

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www.unitaero.com

UNIT
AEROSPACE

Container No: S164799



Part: D5275-041

Job No: 192139

Serial No/Batch: S164799

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/21/19